Quality Control

Work Orde Friday, June 10,											Page 1
Revision ID: Item Name:	D3455-1 Spacer 6/10/2011 6/15/2011	Start Qty: 30.00 Req'd Qty: 30.00			Cust Item I				etup Star		
Approvals:	Process Pla	an:	Date://06-10	Tooling: SPC (Y/N):		ite:		R	tun Star Stop		
Sequence ID/ Work Center II	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #		Accept Qty	Reject Qty		Insp. Stamp
Draw Nbr	Re	vision Nbr							7		
D3455	Rev	v A							· .		4
Hardinge CNC Lath	ie Small	Hardinge CNC LATHE S Memo HARDHING ,□FOLIO R	SMALL GE COBRA⊡I-TURN AS P EV: <u>AJ</u> □DWG REV:_	0.00 0.00 ERIFOLIO FA583 & □2-DEBUF	DWG D3455 RR AS REQUIRED	,		32	\$		
QC Quality Control		QC2- Inspect parts off m Memo	achine FAI/FAIB	0.00	107/4		•	32	Þ	,	
120 		QC8- Inspect parts - seco	ond check	0.00 هـ.هـ	11/07/04			32	<u></u> \$		<u>.</u>

Dart Ae	rospace	Ltd							Ť.
W/O:			WO	RK ORDER CHANG	SES				
DATE	STEP	PR	OCEDURE CHAN	NGE	Ву	Date	Qty Approval Chief Eng / Prod Mgr		Approval QC Inspector
Part No):	PAR #:	Fault Categ	jory:	NCR: Yes	s No DQ	A:	Date: _	
	Re	solution:	Disposition);	QA: N/C	Closed:		Date: _	
NCR:			WORK ORDE	R NON-CONFORM	ANCE (NC	R)			
		Description of NC	Corrective Action		tion B	Vorifie	cation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Dat	l& ∣ _{Secti}		Chief Eng	QC inspecto
						·			

Work Order ID 70529

Friday, June 10, 2011 11:43:37 AM



Page 2

Item ID:

D3455-1

Revision ID:

Item Name: Spacer

Start Date:

6/10/2011

Start Qty: 30.00

Accept



Setup Start

Stop



Required Date: 6/15/2011

Req'd Qty: 30.00

Cust Item ID:

Customer:

Tool ID

Reference:

Approvals:

Process Plan:

QC:

Date: Date: **Tooling:**

SPC (Y/N):

Date:

Date:

Run

Start



Stop

Sequence ID/

Work Center ID

130

Small Fab

Small Fab

Operation Description

Small Fab

Memo

Deburr if necessary.

Set Up/ **Run Hours**

0.00

Tool # Plan

Code

Accept Qty

Reject Qty

Reject Number Stamp

Insp.

140

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

150

Packaging

Packaging

Identify as per dwg & Stock Location:

0.00

Memo

0.00

W/O:			W	ORK ORDER CHANG	ES					
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву		Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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			,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,			-				
Part No	:	PAR #:	Fault Cate	gory:	NCR: Ye	es N	o DQ	A :	Date:	
						QA: N/C Closed: Date:				
NCR:			WORK ORD	ER NON-CONFORMA	NCE (N	CR)				
DATE	CTED	Description of NC		Corrective Action Section			Verific	ation	Approval Chief Eng	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng		n & ate	Secti			QC Inspector
							<u>.</u>			
		·								

Work Order ID 70529 Friday, June 10, 2011 11:43:37 AM

Page 3

Item ID:

D3455-1

Accept



Setup Start

Stop



Revision ID:

Start Date:

Item Name:

Required Date: 6/15/2011

Spacer

6/10/2011

Start Qty: 30.00

Req'd Qty: 30.00



Cust Item ID:

Customer:

Tool ID

Reference:

Approvals:

Process Plan:

Operation

Description

Date:_____

Tooling:

Date:

Start Run

Accept

Qty

QC:

Date:

SPC (Y/N):

Set Up/

Run Hours

Date:_

Tool # Plan

Code

Stop

Reject

Qty

Reject Insp.

Stamp

Sequence ID/

Work Center ID

160

Quality Control

Memo

QC21- Final Inspection - Work Order Release

0.00

0.00

Number

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W/O:			WC	ORK ORDER CHANG	ES				
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Cate	gory:	NCR: Yes	No DQ	A:	Date: _	
	R	esolution:	Dispositio	n:	QA: N/C CI	osed:		Date: _	
NCR:			WORK ORD	ER NON-CONFORMA	NCE (NCF	R)			
DATE	STEP	Description of NC		Corrective Action Section		Verific	cation	Approval	Approval
DATE	SIEP	Section A	Initial Action Descri Chief Eng Chief Eng		Sign 8 Date		ion C	Chief Eng	QC Inspector
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					į				

Picklist Print

Friday, June 10, 2011 11:43:44 AM

Work Order ID: 70529

Parent Item:

D3455-1

Parent Item Name: Spacer



Start Date: 6/10/2011

Required Date: 6/15/2011

Start Qty: 30.00

Required Qty: 30.00

Comments:

IPP REV. A

05.11.17

NEW ISSUE

EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Primary Item Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MDELRINR1.000		Purchased	No		100	f	8.0000	0.022	0.694737	'		
									c /	1	11/	4

Location

MAT055

Loc Qty

Loc Code

114586

Delin 1-250) 1.17/4

This Lime only

.6PA

W/O:			WO	RK ORDER CHANGES					
DATE	STEP	PR	OCEDURE CHAN	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		-							
Part No);	PAR #:	Fault Categ	ory: I	NCR: Yes	No DQ	A:	Date: _	
	Re	esolution:	Disposition	:	A: N/C	Closed:		Date: _	
NCR:			WORK ORDE	R NON-CONFORMAN	CE (NC	R)			
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DATE	STED	Description of NC		Corrective Action Section E	3	Verific	cation	Approval	Approval
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Section E Action Description Chief Eng	<u> </u>	& Verific	cation ion C	Approval Chief Eng	Approval QC Inspector
DATE	STEP		Initial	Action Description	Sign	& Verific			
DATE	STEP	Section A	Initial	Action Description	Sign	& Verific			
DATE	STEP	Section A	Initial	Action Description	Sign	& Verific			
DATE	STEP	Section A	Initial	Action Description	Sign	& Verific			

DART AEROSPACE LTD	Work Order:	10529
Description: Spacer	Part Number:	D3455-1
Inspection Dwg: D3455 Rev: A		Page 1 of 1

	FIRST ARTICLE INSPECTION CHECKLIST											
		X First Arti	cle	Prot	otype							
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of		mments					
Ø0.453	+0.005/-0.000	0.453			$\sim ZJ \sim$,						
Ø1.00	+0.010/-0.001	01.005			/							
0.065	+/-0.010	-065										
					•							
						-						
				1 10								
	1		<u></u>									
Measured by:	A2	Audited by:	丛. A		Prototype	Approval:	N/A					
Date:	117/4	Date:	11/07/0)LI		Date:	N/A					
						Davis - d	Ameraca					
Rev Date A 06.07.17	Change New Issue					Revised by KJ/JLM	Approved					

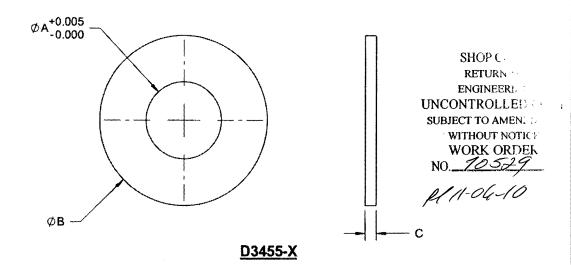
W/O:		(4)	W	ORK ORDER CHAI	NGES	-	-			
DATE	STEP	PRO	OCEDURE CH	ANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Ca	degory:	NCF	R: Yes	No DQ	 A :	Date:	The state of the s
		olution:								
NCR:			WORK OR	DER NON-CONFOR	MANCE	(NCR)			
DATE	CTED	Description of NC	Description of NC Corrective		Section B		Verifi	cation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	on	Sign & Date		ion C	Chief Eng	QC Inspecto
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NOTE	ate & initial a	all ontrice								

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE



DESIGN R	RF RF		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA					
CHECK	ED.	APPROVED	DRAWING NO. D3455	REV. A SHEET 1 OF 1				
DATE			TITLE	SCALE				
	05.0	09.02	SPACER	2:1				
Α	0	5.09.02	NEW ISSUE					

RELEASED 05.12.09



1) SPECIFICATION: D3455-X SPACER

DASH No.

WHERE 'X' IS THE SIZE PER THE FOLLOWING TABLE:

DASH No.	A (in)	B (in)	C (in)
-1	0.453	1.00	0.065
-3	0.386	1.00	0.050

NOTES:

- 1) MATERIAL: DELRIN ROUND BAR (REF. DART SPEC. M-DELRIN-R)
- 2) FINISH: NONE
 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) ALL DIMENSIONS ARE IN INCHES
 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

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W/O:			V.	VORK ORDER CHANG	ES					
DATE	STEP	PRO	OCEDURE CH	IANGE	Ву	Da	te Qty	Approval Chief Eng / Prod Mgr	Approval QC inspector	
		en e								
							.,			
	:									
Part No		PAR #:	Fault Ca	tegory:	_ NCR: Ye	s No	DQA:	Date: _		
					QA: N/C Closed: Date:					
NCR:			WORK OR	DER NON-CONFORMA	NCE (N	CR)		-		
DATE	STEP	Description of NC		Corrective Action Section		v	erification	Approval	Approval	
DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng			Section C	Chief Eng	QC Inspector	
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